

2/26/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

S259373

#1



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1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

D5770-9

Job Sheet 207413



POSITIVE RECALL

POSITIVE  
RECALL

Part No: D5770-9

Part Name: Bushing



Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Job Qty: 8 pcs

24 pcs

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

Priority: Medium

Placed by M. St-Je  
NO 20.02.20

Note: URF 20-522 DWG 5770 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	8 pcs		3/6/20	0.50	0.32	Hardinge - 1		11 20-2-28
110	QC 2	8 pcs		3/6/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		11
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

PRIORITY

Plex 2/26/20 10:04 AM Dart.lajeunesse.marie



120 QC 8	8 pcs	3/6/20	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	m/20/02/24
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	8 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	DAS
				Packaging 3 - 11 - B4B	24
				Packaging 3 - 12 - B4B	9-89
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	



				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	8 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - \*\*\*\*\*DO NOT DO ANY CHAMFER ON THE OUT SIDE OF THE BUSHING\*\*\*\*\* 1-Machine as per folio  
 Descriptions: FD197 FOLIO REV: AA DWG REV: A 2-Debur  
 110 - QC2- Inspect parts off machine FAI/FAIB  
 120 - QC8- Inspect parts - second check  
 130 - Identify as per dwg & Stock Location: \_\_\_\_\_. See note 6.  
 140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M4130NR0.313	4130 Steel Round Bar .313"	.4264 ft (.0533 ea)	100-Hardinge - 1	<u>5055287</u>

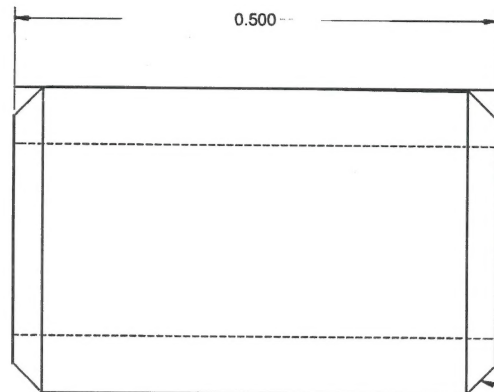
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M4130NR0.313	0	24	0

Part Specifications
Specifications could not be found.

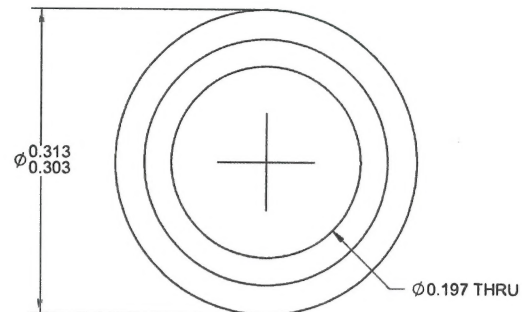
Plex 2/26/20 10:04 AM Dart.lajeunesse.marie







0.03 X 45°  
MAX  
2 PL



**D5770-9 BUSHING**  
(DERIVED FROM AERO DESIGN P/N 84272-01)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 207413  
20.02.27

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

**NOTES:**

- 1) MATERIAL: AISI 4130N ROUND BAR  
PER MIL-S-6758 OR AMS 6348/6370/6528  
REF DART SPEC M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.01 lbs

**RELEASED**

2020 FEB 18 *ND*

APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b>	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	<b>D5770</b>	SHEET 7 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	CP <i>41</i>	<b>BASKET HOOPS</b>	NTS
DATE	20.01.09	<small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

<b>Job:</b> _____ <b>Part No.</b> _____		<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>		<b>DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/>																															
<b>Date :</b> _____		<b>Sequence #:</b> _____		<b>QTY Affected :</b> _____		<b>MRB (QSI042)</b>																													
<b>Description Work Order Deviation</b>				<b>Disposition</b>																															
				<b>Completed By</b>																															
				<b>Lead hand / Supervisor</b>																															
				<b>QC / QA Coordinator</b>																															
<b>Root Cause</b> Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		<b>FAULT CATEGORY</b> <table border="0"><tr><td><input type="checkbox"/> Pressure/Forced</td><td><input type="checkbox"/> Contamination</td><td><input type="checkbox"/> Power Loss/Surge</td><td><input type="checkbox"/> Positioned Wrong</td></tr><tr><td><input type="checkbox"/> Bending</td><td><input type="checkbox"/> Misaligned/off center</td><td><input type="checkbox"/> Folio/Program</td><td><input type="checkbox"/> Outside Tolerance</td></tr><tr><td><input type="checkbox"/> Crushing</td><td><input type="checkbox"/> BOM/Route</td><td><input type="checkbox"/> Grain Direction</td><td><input type="checkbox"/> Drawing</td></tr><tr><td><input type="checkbox"/> Cracks</td><td><input type="checkbox"/> Broken/Damage/Defect</td><td><input type="checkbox"/> Weld</td><td><input type="checkbox"/> Finish</td></tr><tr><td><input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist</td><td><input type="checkbox"/> Incomplete/Unclear Instructions</td><td><input type="checkbox"/> Wrong Stock Pulled</td><td><input type="checkbox"/> Part Lost/Missing</td></tr><tr><td><input type="checkbox"/> Marks/Chatter</td><td><input type="checkbox"/> Drill Holes</td><td><input type="checkbox"/> Out of Sequence</td><td><input type="checkbox"/> Misread</td></tr><tr><td><input type="checkbox"/> Mislabeled</td><td><input type="checkbox"/> Fit/Function</td><td><input type="checkbox"/> Off-set/Set-up</td><td></td></tr></table>						<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Contamination	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Bending	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Tolerance	<input type="checkbox"/> Crushing	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain Direction	<input type="checkbox"/> Drawing	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Weld	<input type="checkbox"/> Finish	<input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist	<input type="checkbox"/> Incomplete/Unclear Instructions	<input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Misread	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Off-set/Set-up	
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<b>Other/Details:</b> _____ _____ _____																																			